

~~502~~

* part engraved batch # 21802 *

DART AEROSPACE LTD	Work Order:	21769 (21802)
Description: Inner Fwd Saddle	Part Number:	D5953
Drawing: D5953 Rev. A	Qty:	6

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg not required</i>	<i>[Signature]</i>	04.10.22	6
2	STORES	Issue material from stock: D6101-007 (7075-T7351) Cut Size 2.50" x 7.50" X 8.25" (Grain along 7.50") Batch: 21802	J.L	05/05/03	6
3	HAAS	Setup W/O No. _____ Setup Inspection last completed <i>NA</i> by <i>NA</i>	J.L	05/05/03	6
4	HAAS	Machine as per folio D5953 Ensure Batch Number is entered	J.L	05/05/04	6
5	HAAS	Deburr and Tumble	J.L	05/05/04	6
6	QC	Inspect Level 1 Fill Out Inspection Sheet	J.L	05/05/04	6
7	QC	Inspect Level 8 Audit Inspection Sheet	<i>[Signature]</i>	05.05.04	6
8	METAL	Acid etch and alodine as per QSI 005 4.1	<i>MM</i>	05/05/12	6
9	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	<i>MM</i>	05/05/12	6
10	QC	Inspect Level 3	<i>CL</i>	05/05/17	6
11	STORES	Pack in foam, identify and stock	<i>CL</i>	05/05/17	6
12	EXPEDITING	Close Work Order Inspect level 21 Cost / Part : <i>147.47</i> <i>545 05/05/19</i> <i>(6)</i> <i>147.47</i>	<i>[Signature]</i>	05/05/25	6

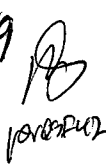
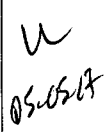

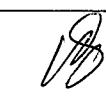
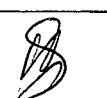
Rev	Date	Change	Revised By	Approved
A	97.03.05			
B	99.04.19	Re-format	DM	
C	00.06.22	Removed P/O for powder coat	EC	
D	02.02.06	Added D part # and inspect level 21	NG	

RELEASED

02/02/06 *[Signature]*

PTO

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/05/17	11	part batch # s/b 21769 material batch (bill of) engraved instead B21802		write both batch #'s on K10004 w/o + on form pkg for traceability	 05/05/17	 05/05/17	 05/05/17	 05/05/17

Part No: D5953 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/05/24

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	21769
Description: Inner Fwd Saddle	Part Number:	D5953
Inspection Dwg: D5953 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5953 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.749	1.748	1.750	1.749		
C	5.245	5.255		5.250	5.249	5.249	5.250		
D	6.995	7.005		6.999	7.001	7.000	7.000		
E	5.745	5.755		5.740	5.750	5.750	5.750		
F	4.745	4.755		4.748	4.749	4.750	4.749		
G	0.313	0.318	DT8686	✓	✓	✓	✓		
H	1.522	1.532		1.526	1.527	1.526	1.526		
I	3.048	3.058		3.055	3.053	3.052	3.054		
J	4.575	4.585		4.580	4.579	4.580	4.580		
K	0.313	0.318	DT8686	✓	✓	✓	✓		
L	0.240	0.260		-241	-251	-253	-253		
M	0.490	0.510		.505	.505	.506	.505		
N	0.240	0.260		.243	.252	.255	.255		
O	7.990	8.010		8.004	8.005	8.005	8.004		
P	0.240	0.260		.241	.256	.251	.252		
Q	0.307	0.312		.312	.311	.312	.312		
R	0.760	0.765		.761	.761	.761	.761		
S	0.490	0.510		.501	.499	.502	.503		
T	1.375	1.395		1.393	1.383	1.383	1.384		
U	2.000	2.020	DT8696 A/B	✓	✓	✓	✓		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L
Date:	05/05/04

Audited by:	EC
Date:	05.05.04

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF RF	#

RELEASED
03.06.18 RF

DART AEROSPACE LTD	Work Order:	21769
Description: Inner Fwd Saddle	Part Number:	D5953
Inspection Dwg: D5953 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5953 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	/	/				
B	1.745	1.755		1.749	1.748				
C	5.245	5.255		5.250	5.249				
D	6.995	7.005		7.000	6.999				
E	5.745	5.755		5.750	5.748				
F	4.745	4.755		4.749	4.750				
G	0.313	0.318	DT8686	/	/				
H	1.522	1.532		1.526	1.527				
I	3.048	3.058		3.053	3.053				
J	4.575	4.585		4.579	4.580				
K	0.313	0.318	DT8686	/	/				
L	0.240	0.260		.247	.249				
M	0.490	0.510		.506	.506				
N	0.240	0.260		.248	.248				
O	7.990	8.010		8.005	8.004				
P	0.240	0.260		.252	.252				
Q	0.307	0.312		.312	.312				
R	0.760	0.765		.761	.761				
S	0.490	0.510		.501	.502				
T	1.375	1.395		1.385	1.382				
U	2.000	2.020	DT8696 A/B	/	/				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	05/05/04

Audited by:	[Signature]
Date:	05-05-04

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF RF	#

RELEASED
03.06.18 RF

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 21, 2004
08:51 am

Work Order No : 0021769
Project Name : D5953
Project For : WK446
Work Order Type : Main
Main WO Number :
House Part Number : D5953
Description : Saddle
Manufactured : Yes
Amount Req'd : 6
Amount Done : 0
Start Date : 10-20-04
Est Finish Date : 11-11-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00